

Date: Wednesday, 11/21/2007 12:45:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 35908A  
 Estimate Number : 12520  
 P.O. Number :  
 This Issue : 11/21/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D205634025-041 07-12-07 Rev NCR 271  
 First Issue : 11 Type : LANDING GEAR Drawing Number : D2580 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 1/15/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: C Revised Steps 06-09-06 JLM  
 Est Rev: D Added SS Wearplates & Gaskets 07-07-09 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



0016162



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG002 N/A

2.0 D25001190 Ext'n 1" Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

34729

SL 7-11-27

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

35776

SL 7-11-27

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

7-11-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35908A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 103488

Sikaflex expire date: 8-7-1

Start Time: 3:00 Date: 7-11-27

Fin Time: 9:00 Date: 7-12-13

SL 7-11-27  
SL 7-11-27

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/SR 7-11-28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

BE 07-12-13

~~2-Drill extra fwd hole as per DEO 9183 using  
drill jig DT8461~~

~~3-Drill extra middle hole as per DEO 9183 using  
drill jig DT8462~~

4-Drill pilot holes for aft cap using DT8215, \*\*\*DO NOT OPEN TO FINISH SIZE\*\*\*

BE 07-12-13

~~5-Drill extra aft holes as per DEO 9183 using  
drill jig DT8463 locating from aft cap hole and aft saddle hole.~~

7.0

QC5

INSPECT WORK TO CURRENT STEP



P70

Comment: INSPECT WORK TO CURRENT STEP

BE 07-12-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-07	5.0	Aft end cut too short. See NCR 271  R.C. Human error	AS/11/12	Fabricate 6061-T6 plug 0.0502x.15T m 105671 Qty 4, from R.B. Plug DEC 9183 holes and weld per AS1004-Rod m 106035 AIR grind flush.	BE 07-12-12	07-12-12	AS/11/12	07-12-07

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35908A

Part Number: D205634045 -041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2576-3 Step *B33464*

*BE 07-12-13*

9.0

D2579

Crossbolt Spacer



Comment: Qty.: ~~24~~ 20.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: *20*

Qty Part Number Description Batch  
*20* ~~24~~ D2579 Spacers *B34789*

*BE 07-12-13*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

*BE 07-12-13*

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

*M106035*

*BE 07-12-13*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*M106035*

*BE 07-12-13*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

*W 7-12-19*

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

~~\*\*\*\*\*DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13, 14 AND 15 (LEAVE AT 0.3840 AS PER DEO 9183)\*\*\*\*\*~~

7-Open aft cap holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*7-12-20*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35908A

Part Number: D205634075 -041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-20 ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 7/12/21 ①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FX 07/12/27 ①

14.0

POWDER COATING

POWDER COATING

Powder coat white per QSI 005  
4.3.5.1

Comment: POWDER COATING

Powder Coat \*\*\*GREEN\*\*\*Sandox (Ref: 4.3.5.8) as per QSI-005 4.3

D.M 07.12.27 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 07/12/28 ①

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B34349

FX

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100/88

FX

18.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104374

FX 07/12/28 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35908A

Part Number: D205634025 2041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: m105729

FL

20.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: m106277

FL

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: ~~m105729~~ B32744

FL

22.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B34354

FL

23.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B35788 (x1)\* B36280 (x1)

FL

24.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B33456

FL

25.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B34805

FL 01/12/28 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/12/28	20:1	AN960 C102 Qty: 50 Batch: <u>m106574</u> FL 07/12/28						0861/08

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35908A

Part Number: D205634045 - 041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D35649	WEARSHOE
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B34807

FL

27.0	D35645	WEARSHOE
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B36111

FL

28.0	D25943	O-Ring
------	--------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
O-Ring  
Batch: B27168

FL

29.0	D25941	Plug
------	--------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Plug  
Batch: B33450

FL

30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 08-07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 08-07

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M106332

02.01.03

02.01.03

FL

07/12/28

①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:45:06 PM  
User: Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35908A

Part Number: D205634048 -041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



08/01/03 (40)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045 -041

Location:

PPP Rev: H

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/09

Job Completion



08/01/09

08.01.09

35908A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **35908A**

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RELEASED  
07-06-28-1

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding and the location ridge. The diagram includes the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the assembly of a bolted joint. The components and dimensions shown are:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- #0.208
- SEAL WITH SIKAFLEX-241/-291
- AN3-SA BOLT (1)
- AN960JD10L WASHER (1) (2 PLACES)
- D2855 CAP

copy

5

D2579 SPACER

D2596 WEB (REF)

ALST-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFORM

1. CHA  
2. INS  
3. WEL  
4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0

91.500





190.0  
(D2500-1)

REFER TO DETAIL A

Technical drawing of a road cross-section showing a 4% grade and a 20.0m radius curve. The drawing includes dimensions for the distance between the hole and the tangent point (1.0m), the total distance (32.0 ± 1.0m), and the hole diameter (ø0.640).

[illegible]

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DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE			
07.02.27			

**DART AEROSPACE LTD.**  
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.	D2580
TITLE	205 SKIDTUBE ASSEMBLY

REV. D  
SHEET 2 OF 3  
SCALE

SCALE



RELEASED  
07 Dec 28

Diagram illustrating the grinding locations for the propeller cross-section. The diagram shows a cross-section of a propeller with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with various parts labeled. The drawing shows a circular cross-section with a central rectangular area. Labels include:

- #0.208
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-5A BOLT (1)
- AN960JD10L WASHER (1)
- D2855 CAP
- SEE NOTE ii)
- 0.40

The drawing is oriented vertically with the text "UNION" and "SU" on the left side.

TO COPY

D2579 SPACER

D2596 WEB (REF)

7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFOR

1. CHA  
2. INS  
3. WEL  
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

Diagram showing the elevation view of the bridge deck. Key dimensions and features include:

- Overall deck width: 37.50
- Distance to aft end of D2596 web: 3.75 (indicated by triangles labeled 3 and 7)
- Reinforcement spacing: 1.750 (indicated by two vertical lines)
- Reinforcement diameter:  $\phi 0.508$  (TYP.) (40 PLACES)
- Reference to Detail A: Indicated by a circle and arrow pointing to the left side of the deck.
- Reference to Detail E: Indicated by a circle and arrow pointing to the right side of the deck.
- Deck width at centerline: 38.0
- Deck width at reinforcement: 34.188
- Deck width at reinforcement: 26.000
- Deck width at reinforcement: 17.375
- Deck width at reinforcement: 8.750
- Deck width at reinforcement: 57.313 (REF.)
- Deck width at reinforcement: 7 EQUAL SPACES 8.188 PITCH
- Deck width at reinforcement: 91.500
- Deck width at reinforcement: 190.0 (D2500-1)

Technical drawing of a horizontal curve. The drawing shows a horizontal line representing the curve, with various dimensions and callouts. Key dimensions include: 5.985, 1.4, 51.340, 5.338 (REF), 3.630 (REF), 39.580, 5.915, 90.508 (8 PLACES), 20.0, 11, 1.0, 13.4, 1.0, 32.0 ± 1.0, and 90.640. Callouts include '4' and '11'.

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

8

0.5

1.5

1.5

H

P

P

P

P

P

P

P

P

P

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY
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PL

1

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D2580

205 614

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REV

SHEET 3.0

50

ASSEMBLY

NO. 133

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliot  
Joint Welding Procedure ti  
Part number and Job number D205 631041 / 535642

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS ti  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-11-27

Qualifier P. J. D.